



Dart Aerospace Ltd.
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Canada

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D2594-1
Job Sheet 198717



Black Sandtex
order 18285

Part No: D2594-1

Job Qty: 35 pcs

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/2/19

Job Tracking No: Black sandtex

Due Date: 8/28/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP E 06.12.11 ecn 836 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Hardinge - 1	35 pcs	8/28/19	8/28/19	0.01	1.01	Hardinge - 1			<i>OK / BM. Aug. 19 2019</i>
110	QC 2	35 pcs	8/28/19	8/28/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			<i>OK 19/08/19</i>
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			



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Container No: S206804



Part: D2594-1

Job No: 198717

Serial No/Batch: S206804

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/19/19

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120 QC 8	35 pcs	8/28/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Handfinish - 1-1 Chemical-B4B	35 pcs	8/28/19	0.00 0.08	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	

DAS
52
J-89

19/08/23

BEB 19-08-23

M138940

START: 9:45 - 01:13:20 FINISH: 10:15

135 Powdercoat - 1 White Gl(A)- 35 8/28/19 0.00 0.05
B4B pcs

Produce

150 QC 3 35 8/28/19 0.00 0.00
pcs

Handfinish - 1 - 17 - B4B	
Handfinish - 1 - 18 - B4B	
Handfinish - 1 - 19 - B4B	
Handfinish - 1 - 20 - B4B	
Handfinish - 1 - 21 - B4B	
Handfinish - 1 - 22 - B4B	
Powdercoat - 1 - B4B	
Powdercoat - 2 - B4B	
Powdercoat - 3 - B4B	BL 19-8-27.
Powdercoat - 4 - B4B	
QC 3 - 10	
QC 3 - 13	
QC 3 - 15	
QC 3 - 17	
QC 3 - 18	
QC 3 - 2	
QC 3 - 28	
QC 3 - 3	
QC 3 - 30	
QC 3 - 34	
QC 3 - 36	
QC 3 - 41	
QC 3 - 51	
QC 3 - 58	
QC 3 - 59	
QC 3 - 68	
QC 3 - 9	
QC 3 - 40	
QC 3 - 19	
QC 3 - 43	
QC 3 - 24	
QC 3 - 61	
QC 3 - 81	
Packaging 3 - 1 - B4B	
Packaging 3 - 2 - B4B	
Packaging 3 - 3 - B4B	
Packaging 3 - 4 - B4B	
Packaging 3 - 5 - B4B	
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	

160 Packaging 3-1 - Stock - B4B 35 8/28/19 0.00 0.00
pcs

AUG 27 2019
DAS
40
9-89

					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	Pc 16 01
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	35 pcs	8/28/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	AUG 27 2019
					QC 21 - SA - 53	
Part Op 100 - (Hardinge) 1-Make as per Dwg D2594-1 and Folio FA262. Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Chemical Conversion Coat per QSI005 4.1) 135 - (White-Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ 150 - (QC3- Inspect Part Finish) 160 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001 170 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M6061T6R0.625	6061-T6 Round Bar .625"	1.8235 ft (.0521 ea)	100-Hardinge - 1	5150604		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Hardinge - 1	M6061T6R0.625	2	26	0		
Part Specifications						
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments	
1	Plug	0.060inches ± 0.005	0.065 0.055	0.063		
2	Plug	0.500inches ± 0.010	0.510 0.490	0.501		
3	Plug	0.625inches ± 0.010	0.635 0.615	0.623		
4	Plug	0.430inches + 0.000 - 0.002	0.430 0.428	0.430		
5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088	0.088		
6	Plug	0.045inches + 0.000 - 0.002	0.045 0.043	0.044		